



TROUBLESHOOTING GUIDE FOR PAD PRINTING

PROBLEM	COLOUR DOES NOT MATCH REPRO COPY				
	<ul style="list-style-type: none"> > too thin > colour too transparent > wrong formulation (if special shade) > changed substrate colour 	<ul style="list-style-type: none"> > depth is varying > cliché material is wrong > screening width is wrong 	<ul style="list-style-type: none"> > wrong form > rough surfaces 	<ul style="list-style-type: none"> > changing substrate colours > repro copy was formulated on another substrate colour 	<ul style="list-style-type: none"> > repro copy was applied by double or single printing
POSSIBLE SOLUTIONS	<ul style="list-style-type: none"> ● adjust colour ● mix more opaque colour ● formulate colour on correct substrate colour 	<ul style="list-style-type: none"> ● measure depth ● use correct type of cliché material ● use correct screening width 	<ul style="list-style-type: none"> ● use correct form ● insert new pad 	<ul style="list-style-type: none"> ● formulate colour shade on surface substrate colour ● preprint white 	<ul style="list-style-type: none"> ● check double/single printing
PROBLEM	INK SPLASHES ON SUBSTRATE				
	<ul style="list-style-type: none"> > too thick > ink builds up on pad 	<ul style="list-style-type: none"> > too deep 	<ul style="list-style-type: none"> > too flat > rough surface 	<ul style="list-style-type: none"> > static charge on surface 	<ul style="list-style-type: none"> > low humidity > process speed too high
POSSIBLE SOLUTION	<ul style="list-style-type: none"> ● re-thin ● mix ink with other thinner 	<ul style="list-style-type: none"> ● measure depth ● use flatter cliché 	<ul style="list-style-type: none"> ● use sharper pad ● use new pad 	<ul style="list-style-type: none"> ● ionize surface 	<ul style="list-style-type: none"> ● check humidity (60-80%) ● slow down printing speed
PROBLEM	DISTORTION IN THE PRINTED IMAGE				
			<ul style="list-style-type: none"> > wrong form > wrong hardness > pressure too high > pressure on cliché and substrate not the same > wrong touch-down of pad 	<ul style="list-style-type: none"> > too soft > not distortion-free > deep spots > edges due to pad deformation 	<ul style="list-style-type: none"> > unsuitable substrate holder > no horizontal position
POSSIBLE SOLUTION			<ul style="list-style-type: none"> ● use correct form ● use correct hardness ● use less pressure ● use same pressure on cliché and substrate ● use other touch-down point 	<ul style="list-style-type: none"> ● other materials ● pad assembly ● special pad 	<ul style="list-style-type: none"> ● stable, firm substrate holder ● substrate must be in a horizontal position to the cliché
PROBLEM	INSUFFICIENT OPACITY				
	<ul style="list-style-type: none"> > too thin > colour too transparent > ink transfer insufficient 	<ul style="list-style-type: none"> > too flat > not screened > motive not inclined > wrong screening width 	<ul style="list-style-type: none"> > too flat > too soft > rough surface 	<ul style="list-style-type: none"> > surface contaminated > dark substrate colour > tension cracks in injection moulded materials 	<ul style="list-style-type: none"> > doctor blade pulls ink out of image (open system)
POSSIBLE SOLUTIONS	<ul style="list-style-type: none"> ● adjust colour ● mix more opaque colour ● check cliché and pad 	<ul style="list-style-type: none"> ● use deeper cliché ● screen motive ● incline motive ● use coarser screening width 	<ul style="list-style-type: none"> ● use sharper pad ● use correct hardness ● insert new pad 	<ul style="list-style-type: none"> ● clean surface ● apply double prints ● use mild ink system with mild thinner 	<ul style="list-style-type: none"> ● use stronger doctor blade, screen motive and incline areas and lines
POSSIBLE SOURCE OF PROBLEM	> INK	> CLICHÉ	> PAD	> SUBSTRATE	> OTHER